

Date: Monday, 09/02/2009 4:24:06 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD BLADE FOLD ASSEMBLY
Job Number : 45640	
Estimate Number : 13531	
P.O. Number :	Part Number : PB674300101
This Issue : 09/02/2009 S.O. No. :	Drawing Number : B6743001 P.1, 2
Prsht Rev. : NC	Project Number : N/A
First Issue : 09/02/2009 Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 43066	Material :
Written By :	Due Date : 18/03/2009 Qty: 2 Um: Each
Checked & Approved By : <u>mf 09-03-03</u>	
Comment : Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300107	Fwd Blade Fold Assembly Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fwd Blade Fold Assembly Weldment

batch: B45052.

mf 09-03-10

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: B45041

mf 09-03-10

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: B45043

mf 09-03-10

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-21

batch: 45038

mf 09-03-10

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-23

batch: B45035.

mf 09-03-10

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Support Assembly

batch: B45028

MF 09-03-10

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long T-Handle Assembly

batch: B45026

MF 09-03-12

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: 412991 x 3, 43093, 1

MF 09-03-04

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: 44977

MF 09-03-04

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: B40062

MF 09-03-04

11.0

D3451041

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B42995 x 1, 45307

MF 09-03-04

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 1x4530, 1x41355

MF 09-03-04

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Job Number: 45640

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D34473	Square Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Square Spacer
batch: B45016

MF 09-03-04

14.0	D34477	Clevis
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Clevis
batch: B43926

MF 09-03-04

15.0	D34479	Swing Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Swing Arm
batch: B45018

MF 09-03-04

16.0	D3445041	Belt Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Belt Assembly
batch: B 39966

MF 09-03-04

17.0	086004	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory
batch: m109356

MF 09-03-04

18.0	MS27039104	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory
batch: m18431

MF 09-03-04

19.0	MS27039123	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
SCREW
batch: m18057

MF 09-03-04

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m110399

mf 09-03-04

21.0	MS21042L4	Nut
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

batch: m109282

mf 09-03-04

22.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: m108183

mf 09-03-04

23.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

mf 09-03-04

24.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

or MS518597 (see engineering) batch: m106421 *

m106421

x4 total

mf 09-03-04

25.0	NAS43DD368	SPACER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060

mf 09-03-04

26.0	NAS1149F0316P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m109031

mf 09-03-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45640

Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	NAS1149F0432P	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

MF 09-03-04

28.0	NAS1149F0632P	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

MF 09-03-04

29.0	NAS1149F0832P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

MF 09-03-04

30.0	AN960JD6	Washer
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Comment: Qty.: 6 2.0000 Each(s)/Unit Total : 12 4.0000 Each(s)

Washer

batch: m6085

MF 09-03-04

31.0	AN410A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m107178

MF 09-03-04

32.0	AN413A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m110865

MF 09-03-04

33.0	AN416A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: _____

or AN415A (see engineering) batch: m110399

MF 09-03-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-03-10	Log # 30.0	ADD 2 WASHERS TO RIVETS FOR P.N. QUICK RELEASE (4 per more per frame)	(P)	09-03-10	X8		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 45640

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M105558

mf 09-03-04

35.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____

or AN6C16A (see engineering) batch: M105831

mf 09-03-04

36.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M18180

mf 09-03-04

37.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

batch: M109119

mf 09-03-04

38.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

cherry rivet

batch: M104214

mf 09-03-04

39.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

batch: _____

or MS17984C410 (see engineering) batch: M109739

mf 09-03-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45640

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

MF 09-03-04

41.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

8" LANYARD

batch: 1 x 102812, m108973 x 3

MF 09-03-04

42.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

LANYARDS

batch: m108973

MF 09-03-04

43.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

SPRING SLOTTED PIN

batch: m17850

MF 09-03-04

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

FD 09/03/11 (2)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joseph (2)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 45666

FD 09/03/11 (2)

W/O:		WORK ORDER CHANGES					
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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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